

Work Order ID 86871

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86871

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Item ID: D2438 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Clamp
 Start Date: 7/06/12 Start Qty: 120.00 ***120*** Cust Item ID:
 Required Date: 8/10/12 Req'd Qty: 120.00 ***120*** Customer:
 Reference:

Approvals: Process Plan: mf Date: 12-09-09 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2438	Rev C								
100	PURCHASING	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	Cut as per dwg D2438								
<u>304 .063</u>	prog rev: <u>C</u>								
	dwg rev: <u>C</u>								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control	Ensure Material Release Note is attached								
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control	(6.786" center to center)								

180 0 Jm 12-7-9

180 0 Jm 12-7-9

150 80 12-07-11

5/10/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Small Fab	Small Fab	0.00							SA 12/07/11
Small Fab	Memo	0.00							
Small Fab	1- Use DT9713 clamp holder to hold clamp in place when forming 2- Bend as per dwg usind DT9709								
140 *140* QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							DAS 16 12/01/13
150 *150* Packaging	Identify as per dwg & Stock Location: 406	0.00							
Packaging	Memo	0.00							

(XLR) 00009

12/2/13 150

W/O:		WORK ORDER CHANGES					
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Item ID: D2438

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Clamp

Stop *NS2*

Start Date: 7/06/12 **Start Qty:** 120.00

120

Cust Item ID:

Required Date: 8/10/12 **Req'd Qty:** 120.00

120

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

12/7/18 *AF*

UMF
12-07-13

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Picklist Print

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Work Order ID: 86871

Parent Item: D2438

Parent Item Name: Clamp

Start Date: 7/06/12

Required Date: 8/10/12

Start Qty: 120.00

Required Qty: 120.00

Comments: IPP: E05.06.28Bending removedKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S16GA
304/316 Sheet .063

Purchased

No

100

sf

317.4900

0.04

5.0526316

5.25 SF

Jun 12-7-9

Location

Loc Qty

Loc Code

MAT020

317.49

122245

157.49

122321

160

122245

150

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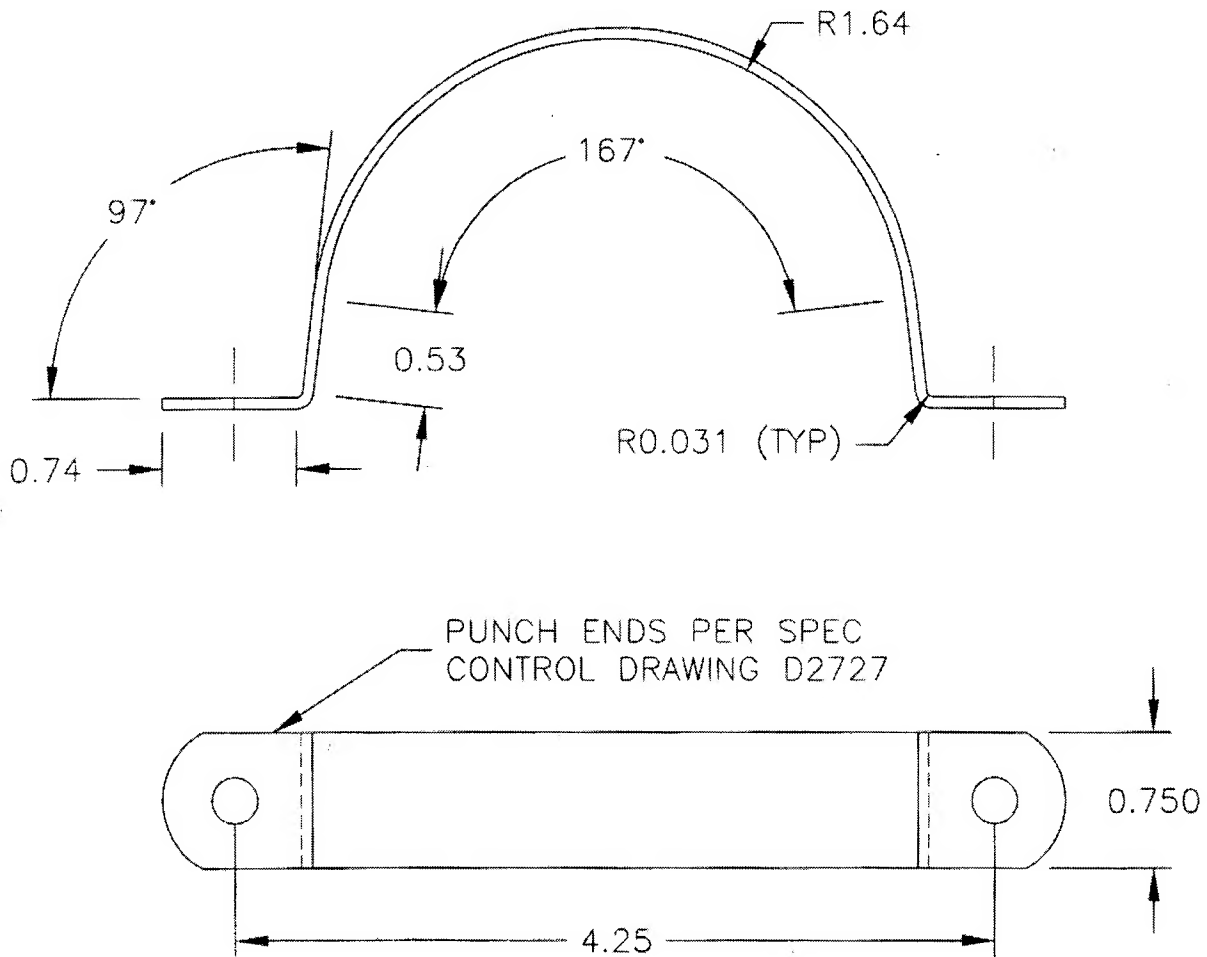
NOTE: Date & initial all entries



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MA</i>	APPROVED <i>KE</i>	DRAWING NO. D2438	REV. C SHEET 1 OF 1
DATE 98.05.12		TITLE CLAMP	SCALE 1:1
A	96.01.24	NEW ISSUE	
B	96.05.13	CHANGE LENGTH	
C	98.05.12	R1.64 WAS R1.438, CHANGE GEOMETRY	

RELEASED
98.06.17 KE

\$88871



FLAT LENGTH: 7.586 END-END
6.786 HOLE-HOLE

MATERIAL: AISI 304/316 SS 0.063 THICK

MINIMUM REQUIREMENT IS ANNEALED CONDITION

00 06 06
CP 00 06 07

Dart Aerospace Ltd

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